



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T102137-107-107
Job Sheet 171726



Part No: RB T102137-107-107

Job Qty: 6 ea

Part Name: Sleeve



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T102137-107 Rev3 IPP Rev A 17.12.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/15/18	0.00	0.00	Start Up Machining-2		12-15-2-25
110	Mori Seiki	6 pcs		2/16/18	0.00	1.50	MORI SL-154		12
120	QC	6 pcs		2/16/18	0.00	0.00	QC2 Machining-4		12
130	QC	6 pcs		2/16/18	0.00	0.00	QC8 Machining-4		12
131	QC	6 pcs		2/16/18	0.00	0.00	QC5 DPA		12
132	Outsource	6 pcs		2/16/18	0.00	0.00	Outsource1	39181	12
133	Packaging	6 pcs		2/16/18	0.00	0.00	Packaging2		12
134	QC	6 pcs		2/16/18	0.00	0.00	QC6		12
140	Packaging	6 pcs		2/16/18	0.00	0.00	Packaging3-1		12
150	QC21-SA	6 Ea		2/16/18	0.00	0.00	QC21		12

Part Op 110 - 1-Machine as per folio FB 845 FOLIO REV: 1 DWG REV: 2-Debur
Descriptions: 132 - 1--Issue P/O to Metcore ; P/O 039181 RC 32-37 2-Bead blast 3- Certificate of Conformity is required
134 - ***NOTE*** Cad plating to be done after load test at final assembly.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140NR0.875	4140 Steel Round Bar 0.875"	1.3500 ft (.225 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140NR0.875	1	0	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

uld not be found.

Plex 2/8/18 6:23 AM Dart.lajeunesse.marie

Container No: S045121



Part: RB T102137-107-107

Job No: 171726

Serial No/Batch: S045121

Revision: RB T102137-107

Inspector:

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER :																									



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039181

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO039181

PO Date: 3/2/18

Due Date: 3/20/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lacelle, LindaPhone:
llacelle@dartaero.com

REVISED

\$

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171547	D2741	Replacement Blade Issue P/O: _____ HARDEN MATERIAL: ULTIMATE TENSILE STRENGTH = 152 KSI MINIMUM YIELD TENSILE STENGHT = 141 KSI (34-40 HRC) SAND BLAST PART AFTER HEAT TREAT \	Firmed	3/27/18	38 pcs	0 pcs	38 pcs	\$18.395263/pcs	\$699.02
NOTE: DO NOT OIL AFTER SANDBLAST NOTE: DETAIL C OF C REQUIRED										

Line Item Note part made from 4130 bar

10 171726 RB Sleeve
T102137- 1--Issue P/O to Metcore ;
107-107 P/O _____
RC 32-37
2-Bead blast
3- Certificate of
Conformity is required

Firmed 3/20/18

6 pcs 0 pcs

6 pcs \$50.00/pcs

\$300.00

✓ 6x

AT 18/03/23

DAS
38
9-68

Line Item Note part made from 4140N round bar 0.875"

11 171725 RB Strap
T102137- 1--Issue P/O to Metcore ;
107-105 P/O _____
RC 46-50
2-Bead blast
3- Certificate of
Conformity is required

Firmed 3/20/18

6 pcs 0 pcs

6 pcs \$50.00/pcs

\$300.00

✓ 6x

AT 18/03/23

Line Item Note part made from 4140N round bar 0.625"

Grand Total: \$1,299.02

Plex 3/22/18 10:01 AM dart.lavoie.chanta

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
325895	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
PO39181	N/A	4140		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	32 - 37 HRC		6	33 - 35 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
6	0.85	RB T102137-107-107 (6) RB T102137-107-107 JOB 171726		
		1 SAC DE PAPIER		

COMMENTAIRES / comments

SALT HARDEN 1550F, 20MIN
TEMPER 1000F, 2HRS

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été fait par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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APPROUVÉ par / Approved by:

Vincent Costello



DATE: 2018-03-19

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
325895	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
PO39181	N/A	4140		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

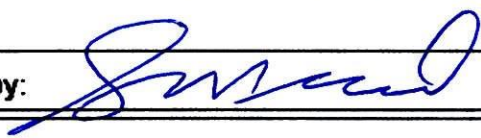
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
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6	0,85	RB T102137-107-107 (6) RB T102137-107-107 JOB 171726 1 SAC DE PAPIER

16/3/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-03-16

APPROUVÉ